

Work Order ID 51903

Wednesday, September 09, 2009 11:06:54 A

Page 1

Item ID: D3793-3 *6Y* Accept

Revision ID: A

Item Name: Wearshoe

Start Date: 9/10/2009 Start Qty: 12.00

Required Date: 9/18/2009 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: *BJ mt* Date: *09-9-09* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3793	Rev A

100 0.00



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

*304
-040*

1-Cut as per Dwg D3793

Dwg Rev: *A*

Prog Rev: *2*

2-Deburr if necessary

110 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

Quality Control

120 0.00



QC8- Inspect parts - second check

QC

Memo

Quality Control

2) 809/10/05

13 9-10-2

(12)

13 9-10-2

(412)

4

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Item ID: D3793-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wearshoe

Start Date: 9/10/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 9/18/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				12	0		
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs								
140 	QC5- Inspect part completeness to step on W/O	0.00				4/2	6		
QC	Memo	0.00							
Quality Control									
150 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				12			
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 8:00 OVEN TEMPERATURE: 320° FINISH TIME: 8:30								

8/10/06

8/10/06

BR 09-10-7

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Item ID: D3793-3

Revision ID: A

Item Name: Wearshoe

Start Date: 9/10/2009 Start Qty: 12.00

Required Date: 9/18/2009 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

= 291 09/10/07

(X12)

Ø

170



Packaging

Packaging

Identify as per dwg & Stock Location: FP-18

Memo

0.00

0.00

291 09/10/07

(X12)

Ø

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/10/07 10
MF 09-10-07

Picklist Print

Wednesday, September 09, 2009 11:07:02 AM

Page 1

Work Order ID: 51903



Parent Item: D3793-3RevA



Parent Item Name: Wearshoe



Start Date: 9/10/2009

Required Date: 9/18/2009

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	245.8640	16.2038 			

18 9-10-2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

245.8640474

110076

31.73

111571

22.1340474

112567

192

112567

DART AEROSPACE LTD		Work Order: 51903
Description: Wearshoe		Part Number: D3793-3
Inspection Dwg: D3793	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.194	*			
0.300 x 0.300	+/-0.010	0.304 x 0.309	*			
1.885	+/-0.010	1.883	*			
4.389	+/-0.010	4.382	*			
6.547	+/-0.010	6.541	*			
6.00	+/-0.030	5.996	*			
6.75	+/-0.030	6.749	*			
2.000	+/-0.010	2.006	*			
4.750	+/-0.010	4.756	*			
9.500	+/-0.010	9.506	*			
14.250	+/-0.010	14.256	*			
17.750	+/-0.010	17.756	*			
26.735	+/-0.010	26.735	*			
Ø0.531 x 0.780	+0.008/-0.001	0.533 x 0.784	*			

Measured by: IB	Audited by: S	Prototype Approval:	N/A
Date: 9-10-2	Date: 09/10/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

8 7 6 5 4 3 2 1

D

D

C

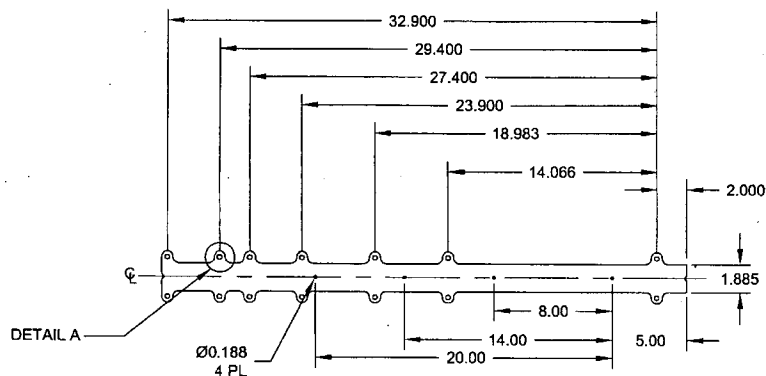
C

B

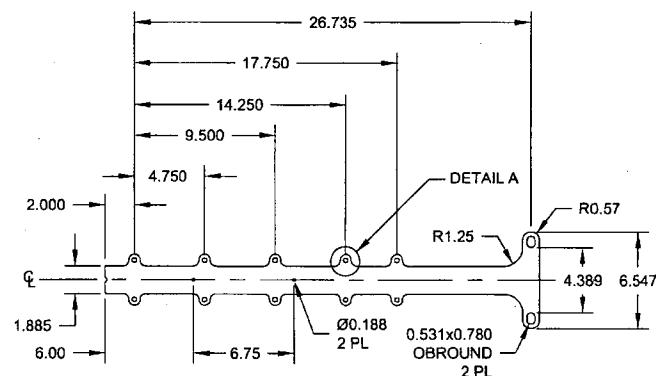
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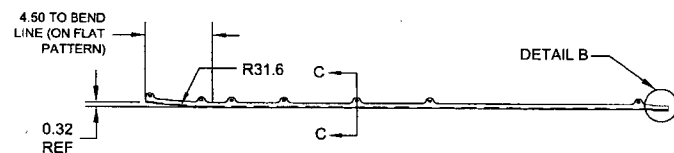
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D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51903

RELEASED
08.05.14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	NEW ISSUE	PH	08.05.14
DESIGN	PH	BY	DATE
DRAWN	PH	DART AEROSPACE USA, INC	
CHECKED		PORT HADLOCK, WA	
MFG. APPR.		DRAWING NO.	REV. A
APPROVED		D3793	SHEET 1 OF 2
DE APPR.		TITLE	SCALE
DATE	08.05.14	WEARSHOE	NTS
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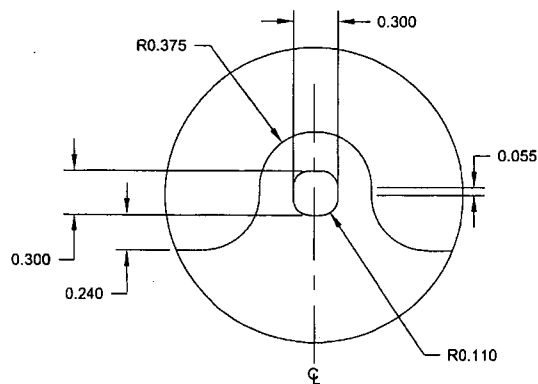
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W/D 31903

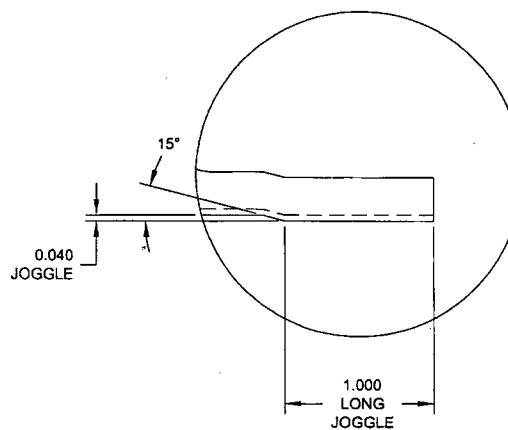
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DETAIL A
SCALE 10X



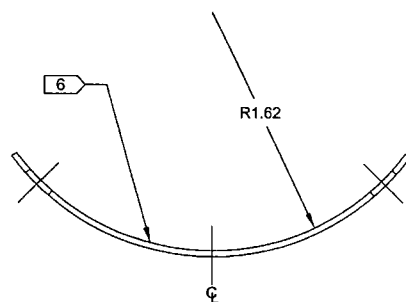
DETAIL B
SCALE 10X

C

C

B

B



SECTION C-C
SCALE 10X

RELEASED
08-05-23 N/D

A

A

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3793	SHEET 2 OF 2
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